

Sup Oct 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:16:55 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER AND LOWER PLATE
Job Number : 34803	
Estimate Number : 12837	
P.O. Number : N/A	Part Number : D35241
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : D3524 UNDER REV
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 33296	Material : N/A
Written By : <u>W</u>	Due Date : 10/12/2007
Checked & Approved By : <u>W</u>	Qty: <u>20</u> Um: <u>20</u> Each
Comment : Est Rev:A New Issue 07-04-18 EC	
Est Rev:B Now CNC Machined 07-06-28 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X0.750 366 (9/21) 6061-T6 Bar 3/8 x 2 3/4



Comment: Qty.: 0.2365 f(s)/Unit Total: 1.1823 f(s) NO BATCH# IN COMPUTER

* 6061-T6 Bar .375" X 3.00"
Batch: M105225 DSP 07/10/01

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks 2.750" Long

DSP 07/10/01

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA699 Rev: 11 & Dwg D3524 Rev: 1

2-Deburr per dwg D3443

SF 07/10/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 07/10/06

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SF 07/10/06 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/06	3	1 scrap, the hole is too big 2 scrap, the hole is too small R.L. Hummon error.	<i>[Signature]</i> 07/10/10	- 2 parts have a hole with a long lip. Scrap - 1 part hole is 0.750" all the way through - one part the part was not machined correctly. Scrap all four parts and Replace	<i>[Signature]</i> 07/10/10	<i>[Signature]</i> 07/10/10	<i>[Signature]</i> 07/10/10	<i>[Signature]</i> 07/10/10
						↓	↓	↓

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:16:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 34803

Part Number: D35241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07-10-10

20

7.0

POWDER COATING

POWDER COATING



M102316



20X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-1 07/10/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-11

20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/11 20 54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20 07/10/11

Job Completion



U 07-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

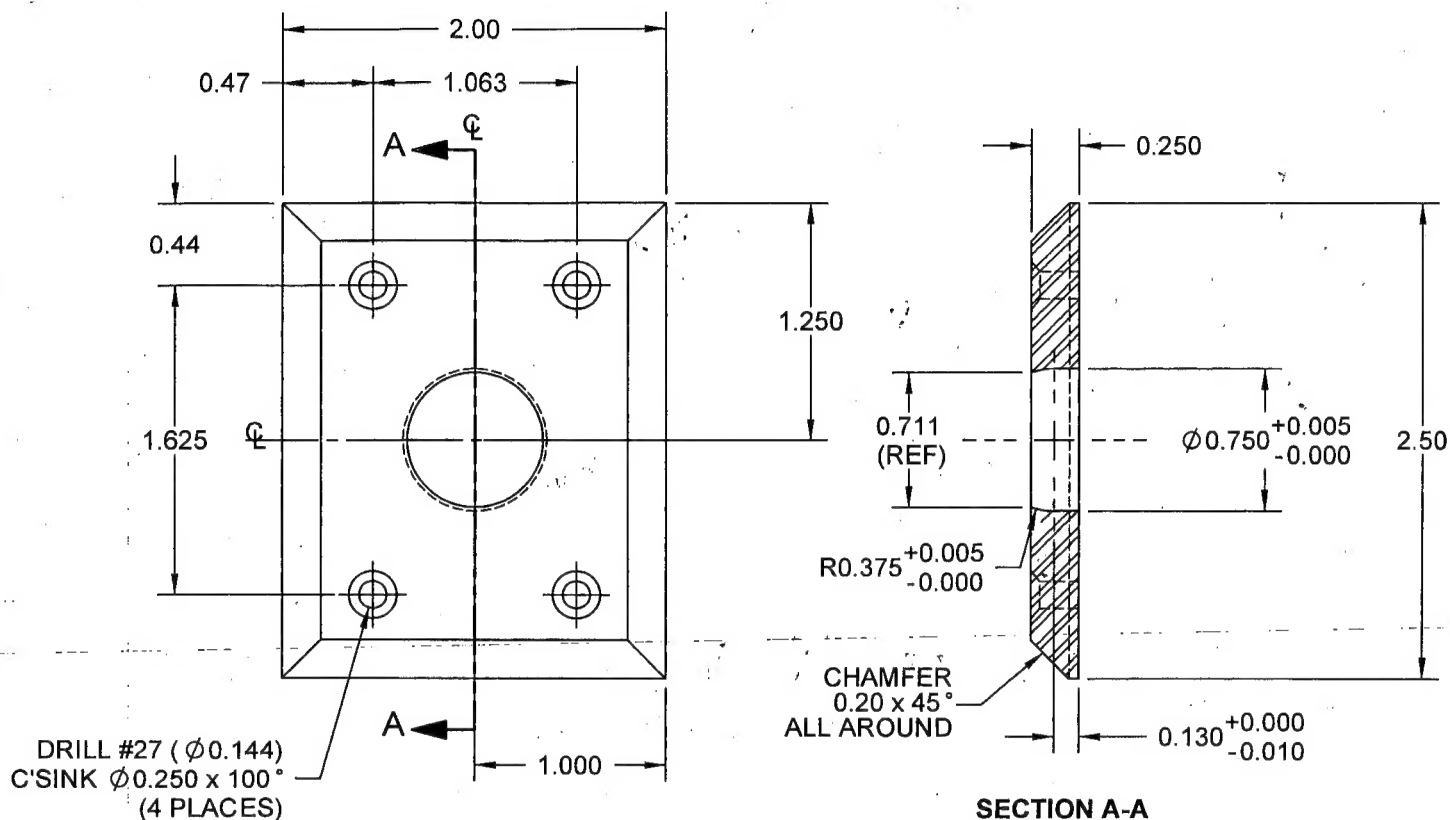
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	



D3524-1 LOWER PLATE

RELEASED
07.08.03

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

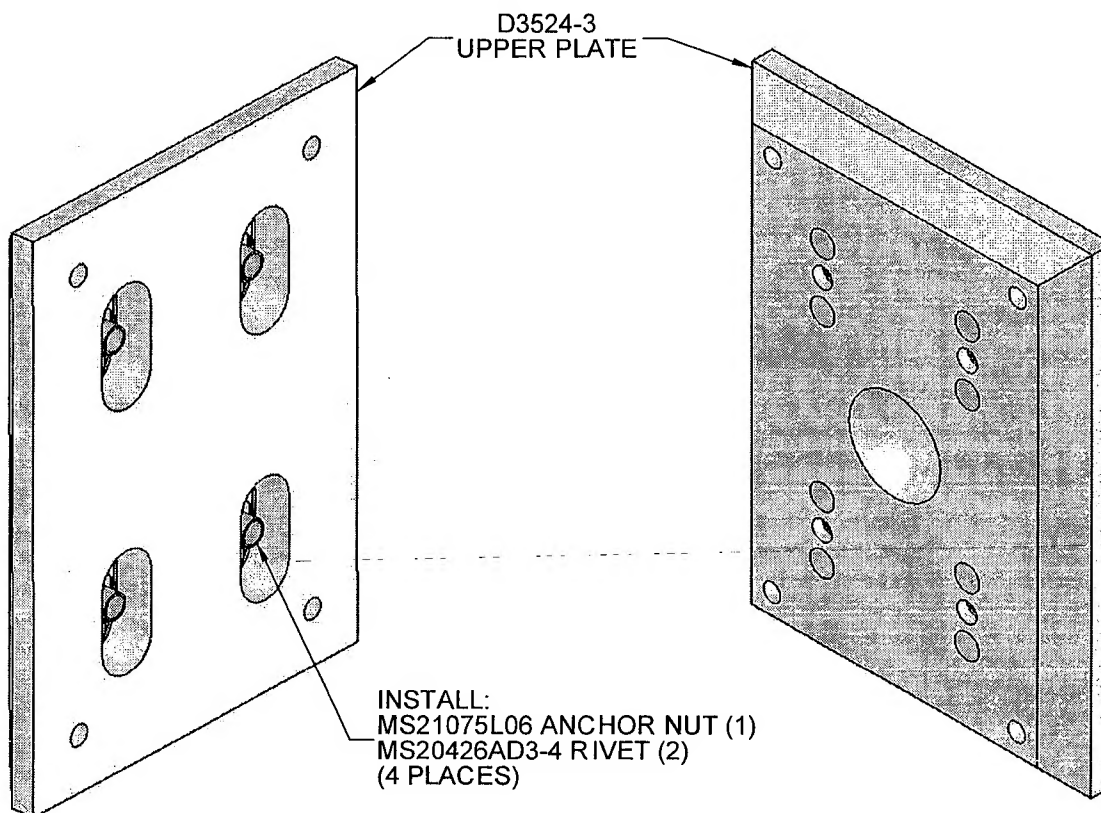
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CHECKED LE	APPROVED #	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1



D3524-041 UPPER PLATE ASSEMBLY

RELEASED
07.08.03 #

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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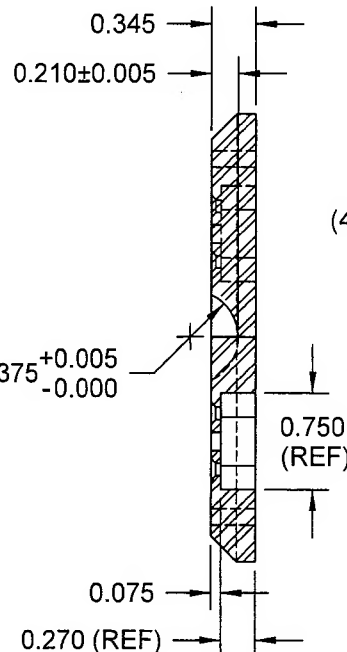
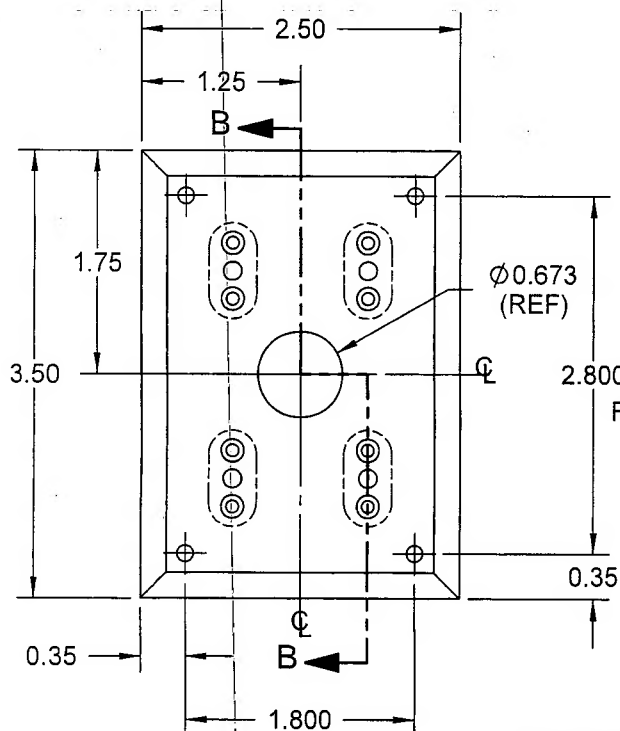
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3524
DATE	07.07.24	TITLE	UPPER AND LOWER PLATE	REV. A SHEET 3 OF 3
		SCALE	2:3	

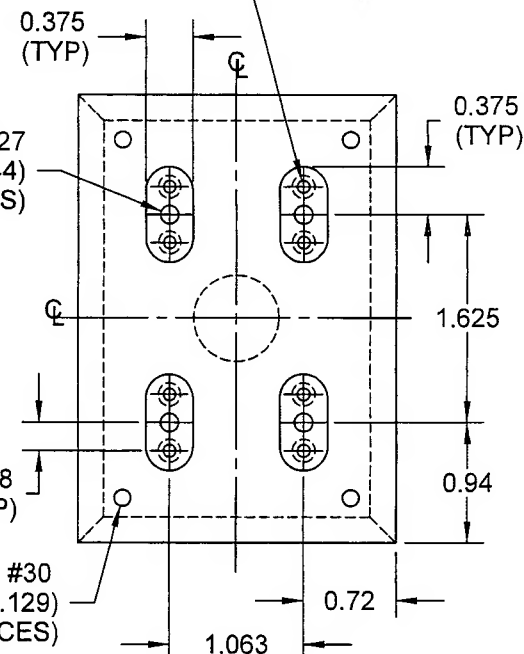
DRILL #40 ($\phi 0.098$)
C'SINK $\phi 0.185 \times 100^\circ$ OTHER SIDE
(8 PLACES)



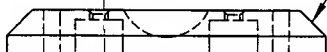
SECTION B-B

DRILL #27
($\phi 0.144$)
(4 PLACES)

DRILL #30
($\phi 0.129$)
(4 PLACES)



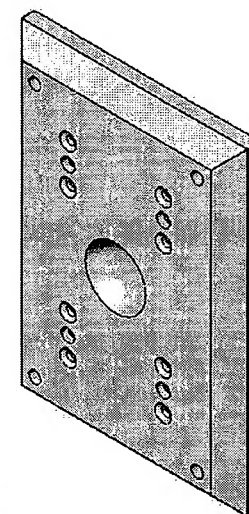
CHAMFER
0.20 x 45°
ALL AROUND



D3524-3 UPPER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
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- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ



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1007-06-03
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DART AEROSPACE LTD		Work Order:	34803
Description:		Part Number:	D3524-1
Inspection Dwg: D3524	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>JS</i>	Audited by: <i>JS</i>	Prototype Approval:
Date: 07/10/06	Date: 07.10.06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	